

Work Order ID 81193

March-12-12 8:42:50 AM

81193

Page 1

Item ID: D3910-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: **40** Stop ***NS2***
 Item Name: Crosstube Lug
 Start Date: 09/03/2012 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 19/03/2012 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut to 1.450" Long

cut @ meter

110 0.00
110
 HAAS 1 *punch* Memo 0.00
 HAAS CNC vertical machine #1 MACHINE AS PER FOLIO FA865 AND DWG
 FOLIO REV: _____
 DWG REV: _____

DEBURR

issue P/O to meter
machine as per drawing D3910 REV. B

P/O. 16414

CL 12/03/12

CL 12/03/12 40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 81193

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Page 2

Item ID: D3910-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug

Start Date: 09/03/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *rec'd*
120

QC
Quality Control

~~QC2- Inspect parts off machine FAH/FAHB~~

0.00

Memo

0.00

*rec'd + inspect
attached c/c to W10*

11/23/14 (40)

130
130

QC
Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

8/21/3/15

counters

(40)

140
140

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

40x Ø m / 12/03/15

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150	<i>M120222</i>								
Powdercoat	Memo	0.00							
Powder Coating									
	<i>START 2 10:25</i>								
	<i>OVER T- 220</i>								
	<i>FINISH 10:55</i>								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <i>57507</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

40 BL 12-3-19

40X PM 12/03/19

6/14/19 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/3/2012
12-03-30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-12-12 8:42:54 AM

Page 1

Work Order ID: 81193

81193

Parent Item: D3910-3

D3910-3

Parent Item Name: Crosstube Lug

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	324.8200	0.13	4.105263			
-------	--	--------------	----	--	--	-----	---	----------	------	----------	--	--	--

D2423

Lug Extrusion

**

CL 12/03/12

Location

Loc Qty

Loc Code

MAT006

324.82

43722

161.5

45800

1

68331

162.32

4.11

D3910-3P

X 40

CL 12/3/14 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Dart Aerospace Ltd

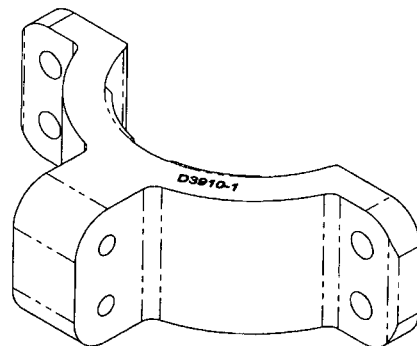
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

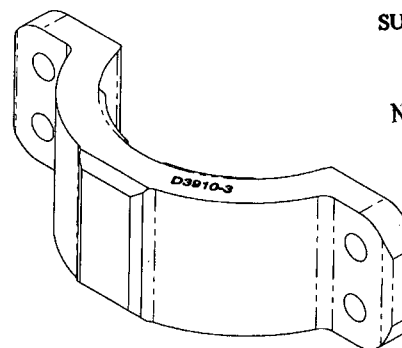
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NOTE: Date & initial all entries



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81193 MCL
12/03/12

RELEASED
2010-03-22
MP

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

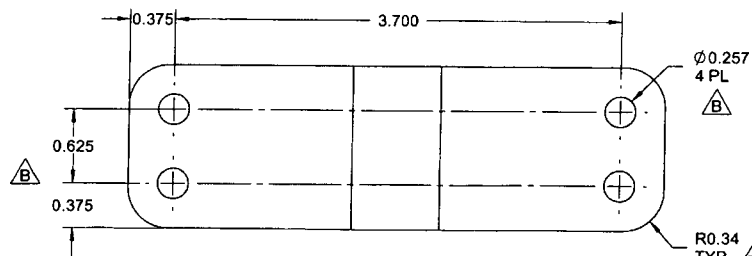
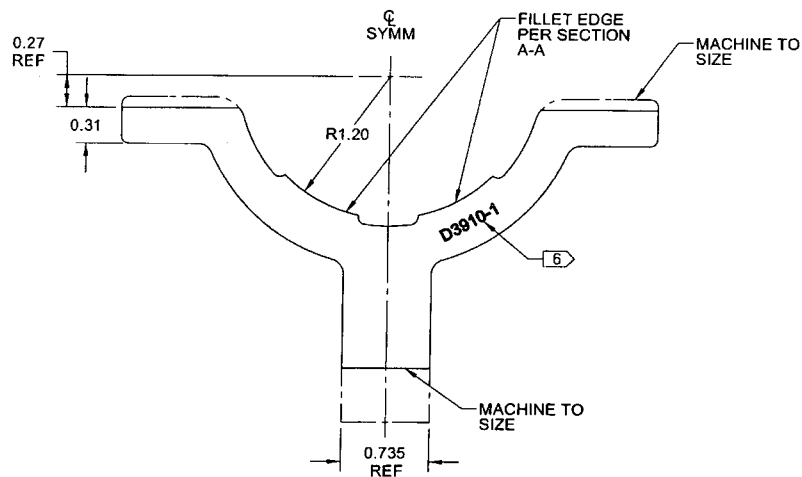
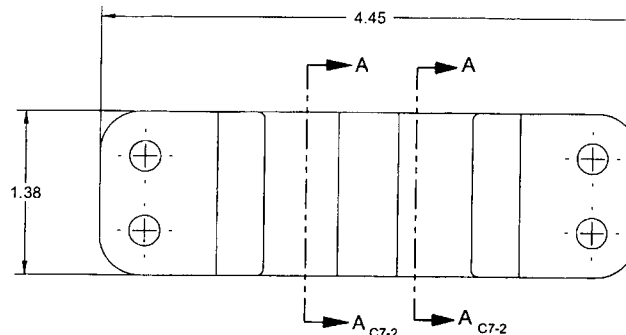
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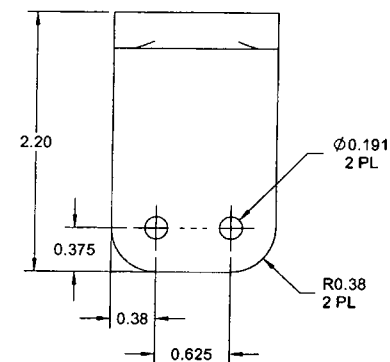


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG



RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. B
MFG. APPR.	1/2	D3910	SHEET 2 OF 3
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	X-TUBE LUG (350)	NTS
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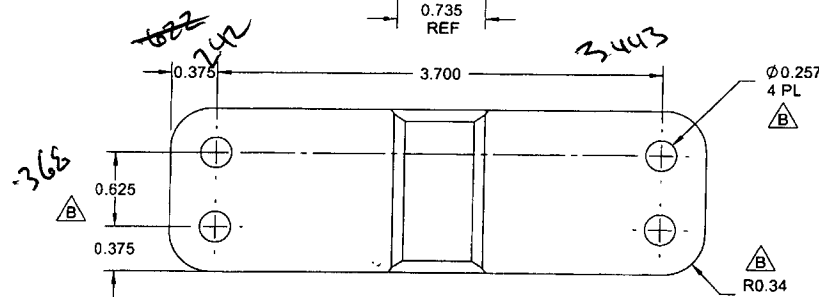
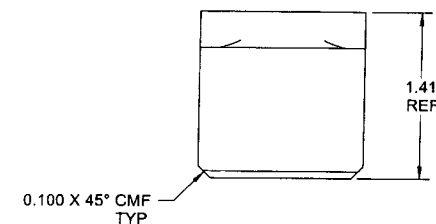
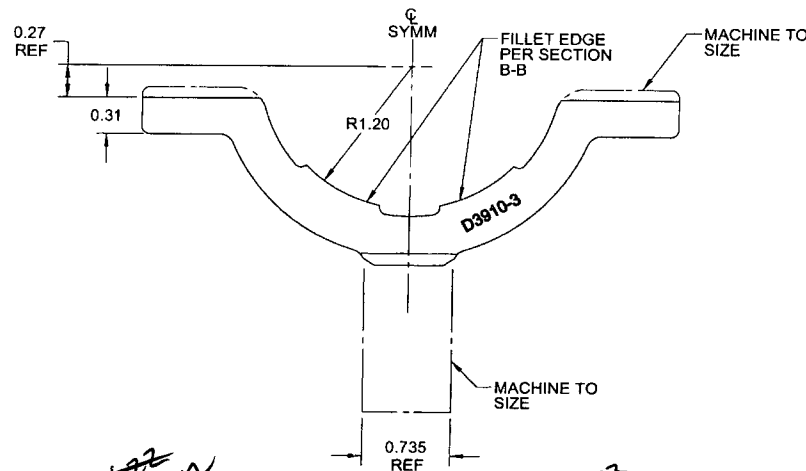
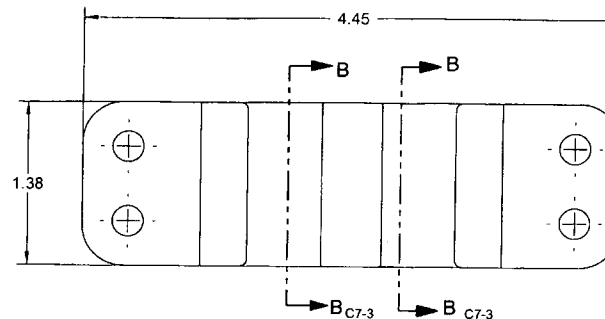
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NOTE: Date & initial all entries



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE X-TUBE LUG (350)	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16414

Purchase Order Date 3/12/12

PO Print Date 3/12/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
613 632 1053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P <i>Rush!</i>	Crosstube Lug	3/23/12 Yes	40.00 Each	Dart Truck <i>10/12/3/14</i>	\$31.5500	\$1,262.00
		Special Inst:	AS PER DWG D3910 REV. B B81193				
2	D4091-1P	LUG	3/23/12 Yes	30.00 Each	Dart Truck	\$26.9500	\$808.50
		Special Inst:	AS PER DWG D4091 REV. A B81168				

PO Total: \$2,070.50



Change Nbr: 1

Change Date: 3/12/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18519
Date: Mar 14, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16414	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Mar 14, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug as per drawing D3910 REV. B B81193	Each	40	40	
D4091-1 Lug as per drawing D4091 Rev.A B81168	Each	30		30
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

40

D3910-3

Crosstube Lug

PO16414

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, March 14, 2012